

Date: Friday, 2/23/2007 8:32:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP		
Job Number	: 30891					
Estimate Number	: 10860					
P.O. Number	: N/A		Part Number	: D30421		
This Issue	: 2/23/2007 S.O. No. : N/A		Drawing Number	: D3042 REV A		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: N/A		Material	: N/A		
Written By			Due Date	: 3/10/2007 Qty: 40 Um: Each		
Checked & Approved By						
Comment	: Est. C 01.11.08 Revised Step 5 SM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 3165

Laser cut per Dwg D3042 GFI

Material: AISI 304/316 SS 0.063" thick

Material release note required

c\07/02/24(40)

2.0	D30421F	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

10/14/23

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

10/04/24(40)counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr any rough edges

Bend as per dwg D3042 N/A made @ gfi

Deburr & tumble. → CAD 07105103 (40)see pto 7.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 30891

Part Number: D30421

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

88 07/05/04

40

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

NIA J

P10

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EgBot 05/04 40

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

9 07/05/04

40

Job Completion



UD-5-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070424	7.0	Have parts deburred & tumbled on step S.O, on this WO. Not a Proc. Change, we will soon make these parts here. <i>No today</i>				<i>[Signature]</i> 070424	<i>[Signature]</i> 070424

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

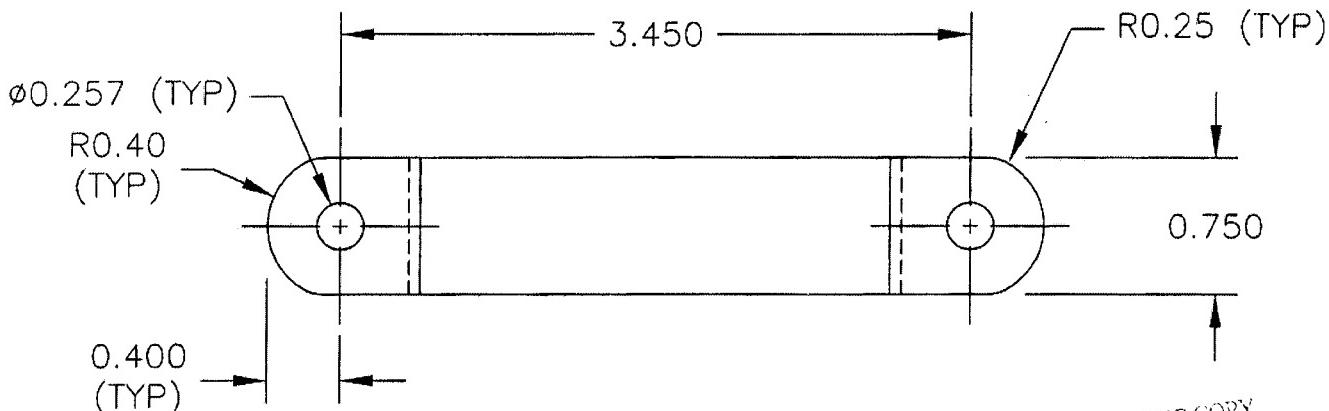
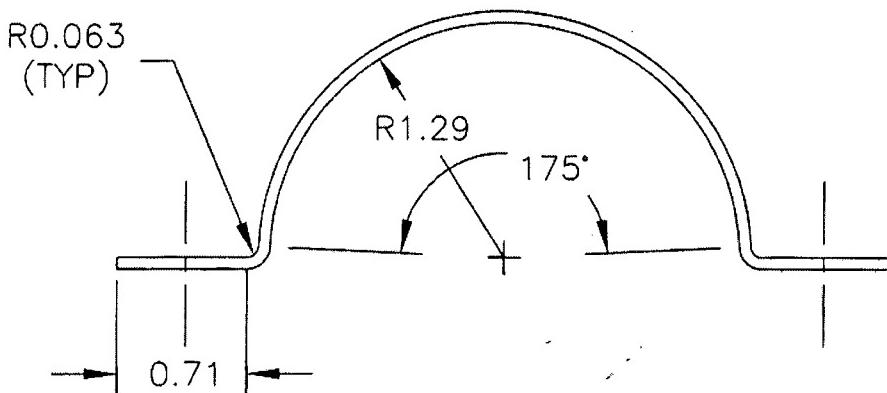
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

COPPIED
1/1

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED CP	APPROVED CP	DRAWING NO. D3042
DATE 01.06.29	TITLE CLAMP	SCALE 1:1
A	01.06.29	NEW ISSUE

RELEASED
01.07.09 CP

D3042-1

- 1) MATERIAL: AISI 304/316 SS ANNEALED PER AMS 5513/5524 0.063 THICK
- 2) FLAT LENGTH: 5.713 END-TO-END
4.913 HOLE-TO-HOLE
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUSPENDED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30891

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180 AVENUE LABROSSE
POINTE-CLAIRe, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO
2007/04/18	0362729

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO	VIA SHIP VIA
DART GFI-0299	J0159868	PO00003165	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO	DESCRIPTION	
40	D30421F	CLAMP CERTIFICATE OF CONFORMANCE REQ	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.



Sigma Metals Inc.
45 Jefrynn Blvd.
Deer Park, NY 11729
A Small Woman Owned Business

(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426

Packing Slip

DATE INVOICE NO.
 2/27/2007 43030

BILL TO	
GFI INC 180 AVENUE LABROSSE POINT-CLAIRES QUE, CANADA H9R 1A1	

SHIP TO	
GFI INC 180 AVENUE LABROSSE POINT-CLAIRES QUE, CANADA H9R 1A1	

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0070966	Net 30	MEC	YELLOW	DEER PARK, NY	59826

ITEM	DESCRIPTION	QTY
SS SHEET	304 STAINLESS STEEL SHEET ANNEALED AMS 5513 063" X 48" X 36" 189 LBS. MILL: ATI LOT# 824074 REPLACEMENT NCR 4680 BOXING CHARGE	8
BOXING	GFI INC. LE MATERIEL REÇU NE SERA ACCEPTÉ SI J'APRÈS VÉRIFICATION DE DIMENSIONS, D'Épaisseur, Poids Et Conditions	1

SIGNATURE

DATE 01 MAR 07

CERTIFICATE OF COMPLIANCE
 THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT
 STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A
 FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT
 ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT
 DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL
 REQUIRED PROGRESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST
 REQUIREMENTS HAVE BEEN MET IN THE FACILITY AND ARE SUBJECT TO REVIEW
 BY THE BUYER. THIS ITEM MEETS ALL SPECIFICATIONS LISTED.

Gregory Saladinio

Quality Control Manager

SHIPPING & RECEIVING WITH SHIPMENT

STANDARD EXCELSIOR & AMERICAN EXPRESS

NOTICE OF SHIPMENT/
PACKING LISTAllegheny Technologies
ACCEPTING MILL

CERTIFICATE OF TEST

AL 6168A-7 400

SOLD TO	FORMS DISTRIBUTION	CUST. CODE	REPEAT ORDER	CASTLE	IN.	SHIPPER NO.	PRODUCT CODE	MILL ORDER NUMBER	DATE SHIPPED
	SHIP TO →	08/18/06 110977	82037-4	DO RATE	PH. ORITY	524046 GOVT CONTRACT	13020102060000	30-096-051	12/12/06 INVOICE
				PRIME SEC.					
				DSO DSO					
				584					

GRADE AND SPECIFICATIONS

ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 5) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516N) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 4/28/04) (ASTM-A-240-05A) (S-1000 DATED 1/3/05) (ASME-SA-240-A05) (01/04/05 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) -- CONTROL TO P&WA REQUIREMENTS FOR LCS --

ITEM PCS	DIMENSIONS W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG #/ CD	SKID #
001	1 48/.062/2129. IF POSSIBLE SHIP WITH LOAD 4111 TO DEL 12/12 C CUST IDENTITY 00640 1 SKID	824074	11066N273	7732493	21585	60	21525	21525	150974	

TYPE HEAT/TEST	--C---	--MN--	--P---	--S---	--SI--	--CR--	--NI--	--MO--	--CU--	--N---
HEAT 824074	.021	1.29	.034	.001	.35	18.28	8.03	.40	.45	.05

ITEM TEST NO 001 7732493

YIELD PSI * TENSILE PSI % ELONG % R/A HARDNESS BEND A 262 PR E GRAIN SIZE
 T 47400. 92500. 58. 83.HRB 82.HRB T PASS PASS 8.
 * Y.S. BY 0.2% OFFSET METHOD

ITEM TEST NO	MELT SOURCE	P&W E-25
001 7732493	1.	TRAN BEND 2.

METALLOGRAPHIC MAGNIFICATION: 100X ETCHEANT USED: OXALIC ACID

GRADE VERIFICATION WAS CARRIED OUT SPECTROSCOPICALLY

PAGE 01 - CONTINUED ON PAGE 02

CONSIGNEE - Please Note - This consignment was turned over to carrier in first class condition, being correctly packed, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-6577. CAUTION: Breathing that makes lumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING

Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires veuillez téléphoner au numéro suivant 724-226-6577. Attention: les traitements entraînent la production de vapeurs, poussières, ou solutions pouvant être cause de maladies pulmonaires. Pour plus de renseignements se référer aux fiches d'information-sécurité.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgment.

CM Napoléon
C. M. Napoléon -
Manager, Technical Information

12/12/06 10:17:44

NOTICE OF SHIPMENT/
PACKING LIST

Allegheny Technologies

CERTIFICATE OF TEST

CUST. CODE		ACCEPTING MILL		SHIPPER NO.		PRODUCT CODE		MILL ORDER NUMBER	DATE SHIPPED	
REPEAT ORDER 82037-4	DO RATE 26	CASTLE, IN.	PR- ORITY 584	524046 GOVT CONTRACT		13020102060000 MATL	30-096-051 SHIPPING LOCATION 1124 NEW CASTLE	IN	12/12/06 INVOICE 072704	
SOLD 72	FORMS DISTRIBUTION SHIP SPEC	PRIME DSO 584	SEC. DSO							

GRADE AND SPECIFICATIONS

ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 5) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516N) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 4/28/04) (ASTM-A-240-05A) (S-1000 DATED 1/3/05) (ASME-SA-240-A05) (01/04/05 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) -- CONTROL TO P&WA REQUIREMENTS FOR LCS --

AUSTENITIC STAINLESS STEELS ARE SOLUTION ANNEALED AT 1900 DEGREES FAHRENHEIT MINIMUM (1038 C) AND RAPIDLY COOLED TO DEVELOP THE SPECIFIED PROPERTIES. EVIDENCE OF CONFORMANCE IS PROVIDED BY THE ABILITY OF THE MATERIAL TO MEET THESE SPECIFIED MECHANICAL AND CORROSION REQUIREMENTS

ALLEGHENY LUDLUM DOES NOT USE MERCURY IN THE TESTING OR PRODUCTION OF ITS PRODUCTS. TO THE BEST OF ALLEGHENY LUDLUM'S KNOWLEDGE, UNDERSTANDING, AND BELIEF, THIS MATERIAL WAS NOT CONTAMINATED BY MERCURY WHILE IT WAS BEING PRODUCED IN OUR FACILITIES.

NO WELDS/WELD REPAIRS PERFORMED.

THE NUMERIC CODES SHOWN UNDER MELT SOURCE CAN BE INTERPRETED AS FOLLOWS:

1. - MATERIAL MELTED AND ROLLED IN THE UNITED STATES AND COMPLIES WITH DFARS EDITION 1998, SECTION 252.225-7014
2. - FOREIGN MELT AND ROLLED IN THE UNITED STATES

ALC HOLDS SEVERAL QUALITY AND LABORATORY CERTIFICATIONS THAT INCLUDE ISO-9001:2000, AS9100, AD 2000-MERKBLATT W0, AND EU PRESSURE EQUIPMENT DIRECTIVE 97/23/EC, NADCAP MATERIALS TESTING, ISO/IEC17025, GEAE S400. REFER TO WWW.ALLEGHENYLUDLUM.COM TO ACCESS THE CURRENT ALC QUALITY CERTIFICATIONS.

ALLEGHENY LUDLUM / ALLEGHENY RODNEY WORKS TO THE ROLLS ROYCE RR9000:SABRE REQUIREMENTS.

PAGE 02 - CONTINUED ON PAGE 03

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WARNING

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The above is a true copy of copy on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgement.

C. M. Napoli
Manager, Technical Information

12/12/06 10:17:44

C. M. Napoli

NOTICE OF SHIPMENT/
PACKING LIST

Allegheny Technologies

SOLD TO →	FORMS DISTRIBUTION	CUST. CODE 08/18/06 110977	ACCEPTING MILL NEW CASTLE, IN.	SHIPPER NO. 524046 GOVT CONTRACT	PRODUCT CODE 13020102060000 MATL	MILL ORDER NUMBER 30-096-051 SHIPPING LOCATION	DATE SHIPPED 12/12/06 INVOICE
SHIP TO →	SHIP TO →	REPEAT ORDER 82037-4	CASTLE, IN. DO RATE PRIO RITY 261	PRIME SEC. DSO DSO 584	1124 NEW CASTLE	IN	072704

CERTIFICATE OF TEST

GRADE AND SPECIFICATIONS

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THIS CERTIFICATE OF TEST SHALL NOT BE REPRODUCED EXCEPT IN FULL WITHOUT THE WRITTEN APPROVAL OF THE COMPANY. THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. MATERIAL WAS MANUFACTURED IN ACCORDANCE WITH THE ALC QUALITY MANUAL REVISION 16 DATED 08/07/2006. ALC HOLDS SEVERAL QUALITY CERTIFICATIONS THAT INCLUDE ISO-9001, DIN EN 10204-2005 - 3.1. ALLEGHENY LUDLUM IS APPROVED AS A MANUFACTURER ACCORDING TO AD-MERK BLATT WO/TRD100 AND THE PRESSURE EQUIPMENT DIRECTIVE PED 97/23/EC. TESTING WAS PERFORMED AT ALC NADCAP AND ISO/IEC 17025 APPROVED LABORATORIES LOCATED AT NATRONA HEIGHTS, BRACKENRIDGE, LATROBE, MIDLAND AND LEECHBURG PA FACILITIES OR A NADCAP AND ISO/IEC 17025 ACCREDITED LABORATORY.

ALLEGHENY LUDLUM PERFORMS CHEMICAL ANALYSIS BY THE FOLLOWING TECHNIQUES:

C, S BY COMBUSTION/INFRARED
N, O, H BY INERT FUSION/THERMAL CONDUCTIVITY
Mn, P, Si, Cr, Ni, Mo, Cu, CB, Co, V BY WDXRF
B BY OES
Al AND Ti (>=0.10%) BY WDXRF, OTHERWISE BY OES
Pb, Bi, Ag BY GFAA

SIGMA METALS INC.

THESE TEST REPORTS APPLY TO:

GFIP.O. 0070966S/I 59828PCS. 6 FTG FTGNET 189 DATE 2.27.07

ISSUED BY ALLEGHENY LUDLUM - 12/13/06 07:51
CAROLE DEFILIPPI / QUALITY ASSURANCE DEPT.

PAGE 03 - FINAL PAGE

CONSIGNEE..Please Note--This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment at it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

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C. M. Napoli
Manager, Technical Information